

**Work Order ID 59322**

Tuesday, June 01, 2010 9:08:45 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 6/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/6/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per  
dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 4113328

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.06.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/10/06/17

f0

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

1- Plug holes prior to

0.00

M 114841

1ST COAT:

START TIME: 1:45

OVEN TEMPERATURE: 400°

FINISH TIME: 2:15

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 2:40

OVEN TEMPERATURE: 400°

FINISH TIME: 3:10

D Bl 10-6-17.

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 6/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC3- Inspct Part Finish	0.00							
QC Quality Control	Memo	0.00							<i>EP 5/0/06/18 @</i>
150 	Identify as per dwg & Stock Location: <i>w/o 6-A</i>	0.00							
Packaging Packaging	Memo <i>59321</i>	0.00							<i>EP 5/0/06/18 @</i>
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>10/06/18 MF</i> <i>10-6-18</i>

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 01, 2010 9:08:52 AM

Page 1

Work Order ID: 59322

Parent Item: D2221

Parent Item Name: 350 Basket Base





Start Date: 6/1/2010

Required Date: 6/8/2010

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1	Manufactured	No	100	Each	16.0000	1	1	
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		WA		16				
		57182		1				
		57499		3				
		58122		12				
✓ D2221-5	Manufactured	No	100	Each	12.0000	2	2	
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		WA		12				
		57500		4				
		58027		8				
✓ D2221-7	Manufactured	No	100	Each	6.0000	1	1	
								
Rib								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		WA		6				
		57501		2				
		57805		4				
✓ D2232-3	Manufactured	No	100	Each	10.0000	2	2	
								
Basket Hinge								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		WA		10				
		57502		4				
		57793		6				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: 350 Basket Base

Start Date: 6/1/2010

Required Date: 6/8/2010



Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00



Required Qty: 1.00

D2235-1 Manufactured No 100 Each 18.0000 2 2  
  
 Basket Rib  SM 10/06/14

Location	Loc Qty	Loc Code
WA	18	
57593	2	
57792	6	
59035	10	

D2581 Manufactured No 100 Each 30.0000 2 2  
  
 Mounting Bracket  B59121 ② SM 10/06/14

Location	Loc Qty	Loc Code
WA	30	
46086	2	
51745	2	
57185	1	
58301	5	
58687	20	

D3442-1 Manufactured No 100 Each 24.0000 2 2  
  
 Shim  SM 10/06/14

Location	Loc Qty	Loc Code
WA	24	
56579	12	
58028	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

*Tuesday, June 01, 2010 9:08:52 AM*

**Parent Item:** D2221



**Parent Item Name:** 350 Basket Base

**Comments:** IPP Rev:J 05.09.02 Added D3442-1 □KJ/JLM  
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

**Start Date:** 6/1/2010**Required Date:** 6/8/2010



**Start Qty: 1.00**

**Required Qty: 1.00**

D3825-041	Manufactured	No	100	Each	4.0000	2	2
							B58998 @ <i>MS</i> 10/06/14
Rib Assembly (Basket End)							




<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
58025	4	

D3826-041      Manufactured      No      100      Each      4.0000      2      2



  B58981 (2) *14* 10/06/14

Rib / Gusset Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
57835	4	

D3827-041	Manufactured	No	100	Each	7.0000	1	1
							
Rib Assembly (Inboard)							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	7	
	57219	1	
	57802	6	

D3832-1	Manufactured	No	100	Each	5.0000	1	1	<i>Pl 10.06.16</i>
								
Mesh (Base)								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	5	
57791	2	
58165	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Parent Item: D2221



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Start Date: 6/1/2010

Required Date: 6/8/2010

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

7.0000

2

2



Mesh (Base End Face)



*PL-0.06.16*

Location

Loc Qty

Loc Code

WA

7

56396

1

57834

6

*B59184 → ②*

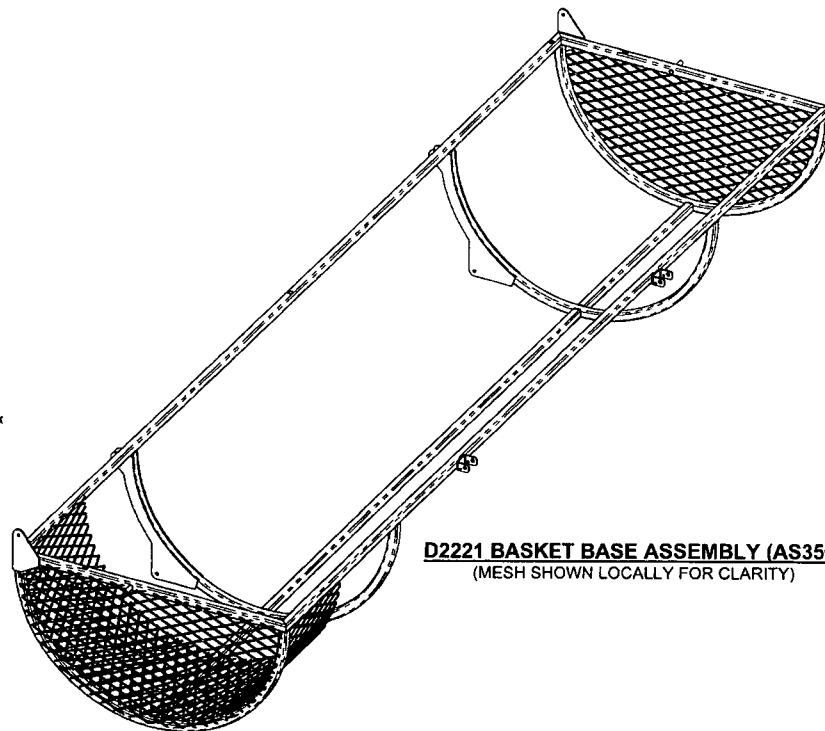
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**NOTE:** Date & initial all entries



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISED  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JSS		
CHECKED	JSS	DRAWING NO.	REV. H
MFG. APPR.	JSS	D2221	SHEET 1 OF 5
APPROVED	JSS	TITLE	SCALE
DE APPR.	JSS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: 42.00 lbs APPROX
  - 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOW BY  
RETURNED  
ENCLOSURE  
UNCONTROLLED  
SUBJECT TO A  
WITHIN THE  
WORK ORDER  
NO. 59322

210-6-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

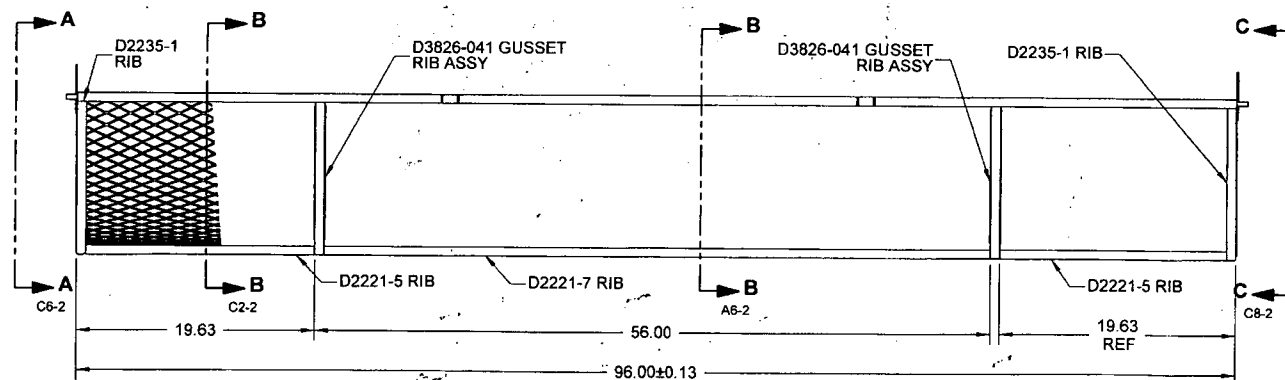
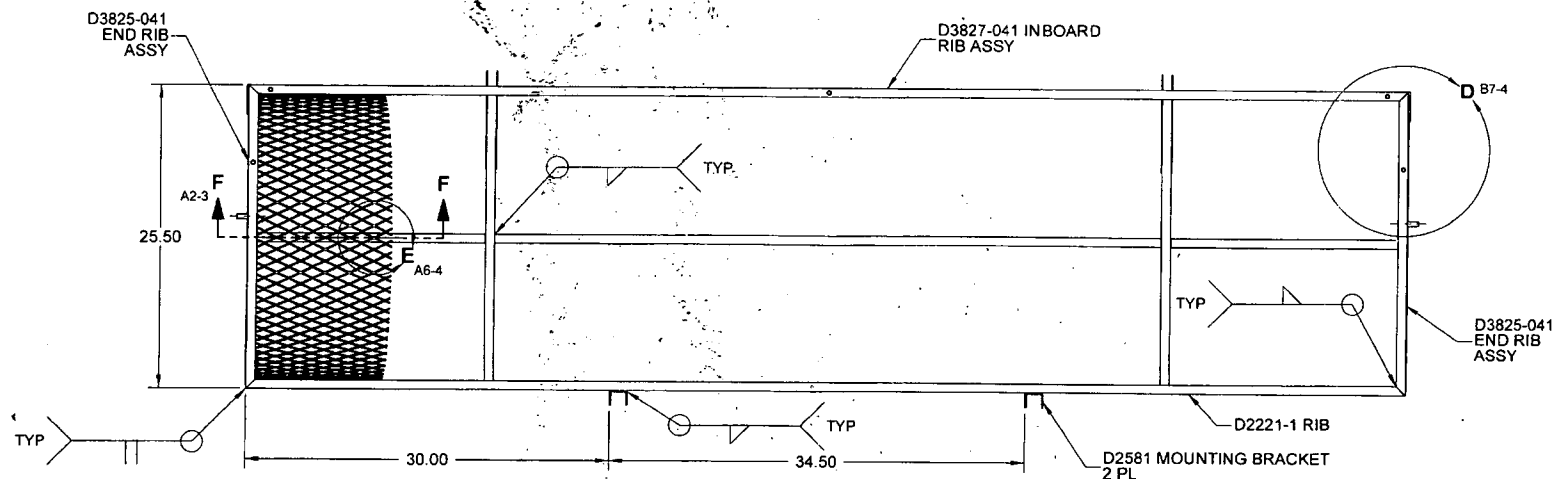
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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

**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18 NED

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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WU 59322

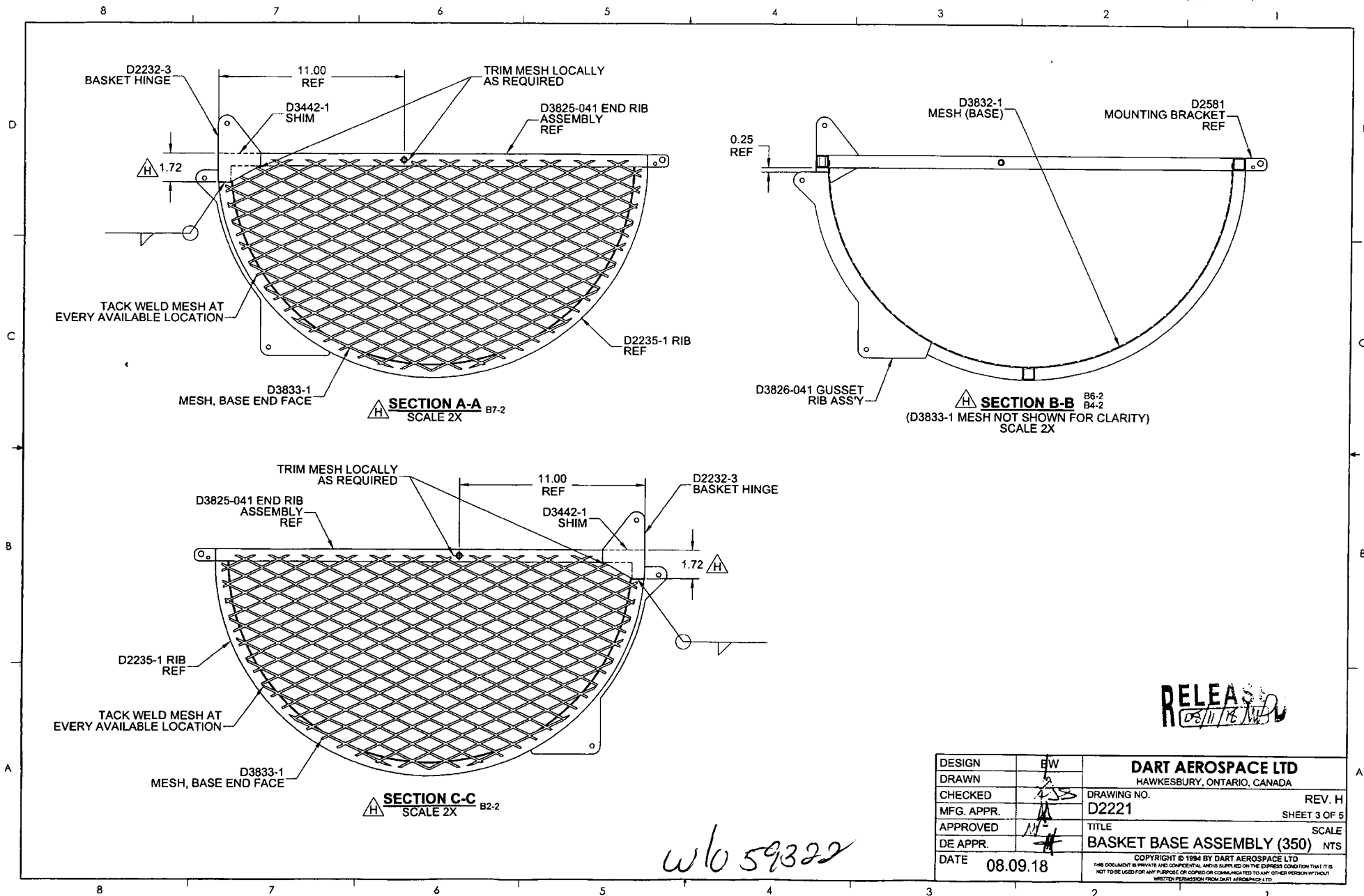
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RELEASE  
05/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4-3-3	DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.	1	SHEET 3 OF 5	
APPROVED	11	TITLE	SCALE
DE APPR.	1	<b>BASKET BASE ASSEMBLY (350)</b>	NTS
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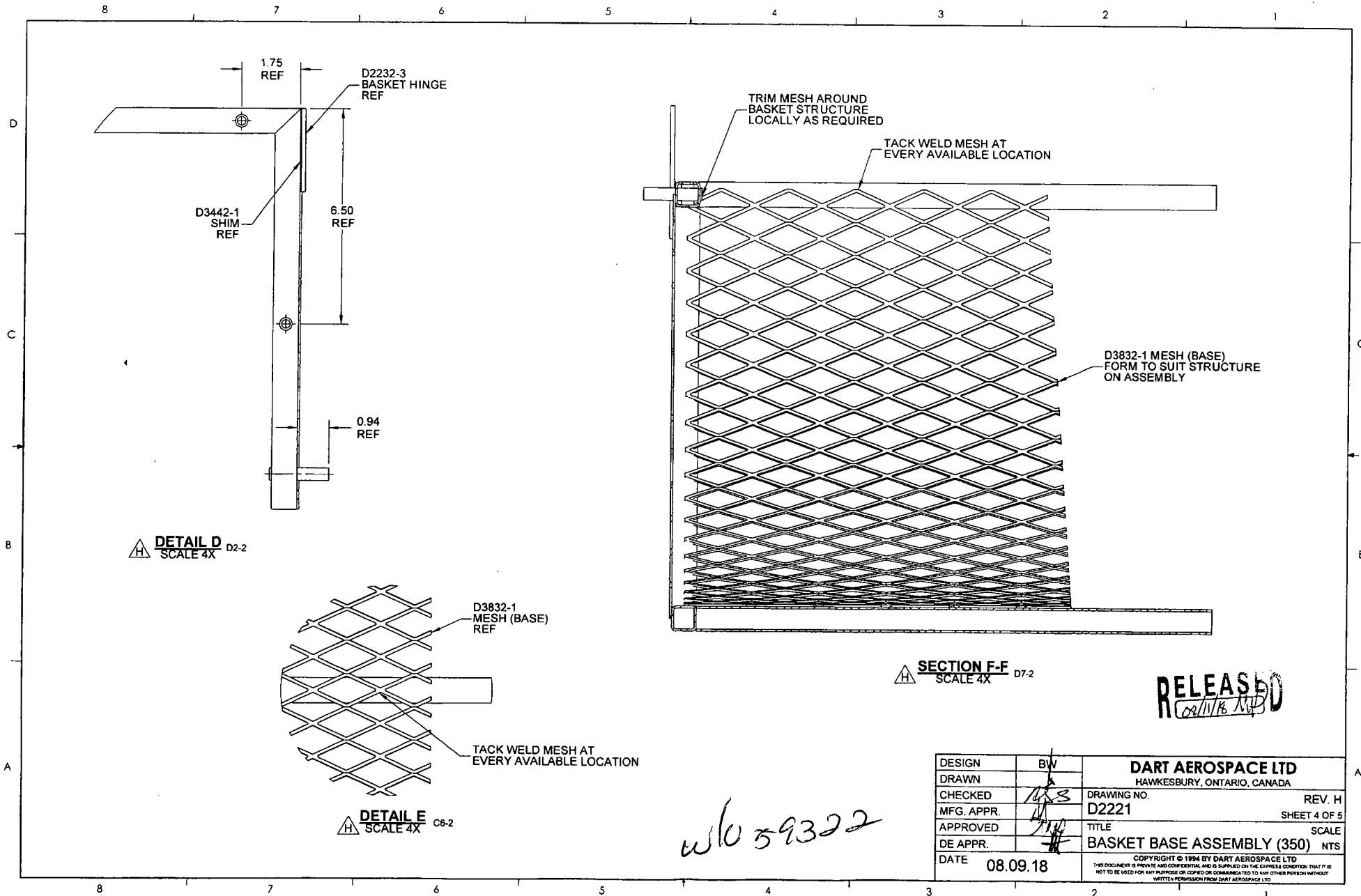
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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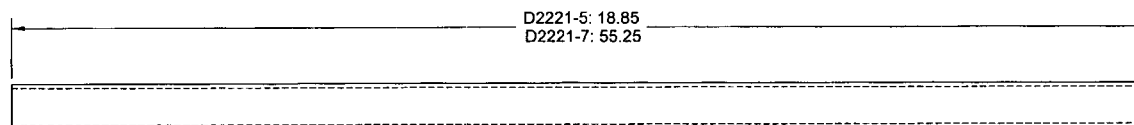
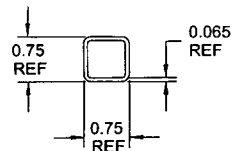
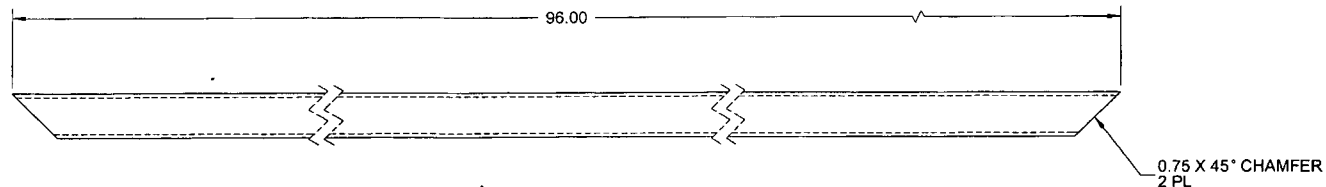
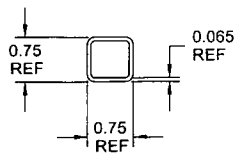
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

*W659322*

**RELEASED**  
*08/10/18 WJ*

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADS	DRAWING NO.	REV. H
MFG. APPR.	ADS	D2221	SHEET 5 OF 5
APPROVED	ADS	TITLE	SCALE
DE APPR.	ADS	<b>BASKET BASE ASSEMBLY (350)</b> NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries